

ABSTRACT OF THE DISCLOSURE

A method for stacking cases on a pallet includes supplying cases to a buffer, determining physical characteristics of buffer cases including dimensions of a case
5 base and case height, and determining available positions on the pallet where a buffer case can be placed. Rules for selecting a case from the buffer for placement on the pallet are applied to at least a portion of the buffer cases to identify a selected buffer case that satisfies at least one of the rules and a corresponding place on the pallet for the selected case. Then the selected case is removed from the buffer and placed on the
10 pallet in the corresponding place by an industrial robot.